

Work Order ID 67594

Page 1

Monday, March 28, 2011 11:51:09 AM

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: 140328

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

304 - 640

Memo

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

PB11-4-5

(13)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

PB11-4-5

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

8 u104105

(X3)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 67594

Monday, March 28, 2011 11:51:09 AM



Page 2

Item ID: D3535-23

Accept



Setup Start



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Item Name: Wearshoe

Stop



Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Brake NC

Memo

0.00

SB 116400

(13)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8uloxlo6

(13)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

1:20

OVEN TEMPERATURE:

FINISH TIME:

1:50

13

BL 11-4-6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67594

Monday, March 28, 2011 11:51:09 AM



Page 3

Item ID: D3535-23

Accept



Setup

Start

**Revision ID:****Item Name:** Wearshoe

Stop

**Start Date:** 3/28/2011 **Start Qty:** 12.00**Cust Item ID:****Required Date:** 3/31/2011 **Req'd Qty:** 12.00**Customer:****Reference:****Approvals:** Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID**

160



QC

Quality Control

**Operation
Description**

QC3- Inspect Part Finish

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

13 4 31-10-07

170



Packaging

Packaging

Identify as per dwg & Stock Location:

FP-21

0.00

13 BL 11-4-7

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/4/10 JJ

M 11-04-7
(13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, March 28, 2011 11:51:15 AM

Work Order ID: 67594



Parent Item: D3535-23



Parent Item Name: Wearshoe

Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	109.0000	1.3615	17.19789		13 (1-4-5)	

304/316 .040 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	109	
115953	1	
116437	44	
116623	64	116623

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	67594
Description: Wearshoe		Part Number:	D3535-23
Inspection Dwg: D3535	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

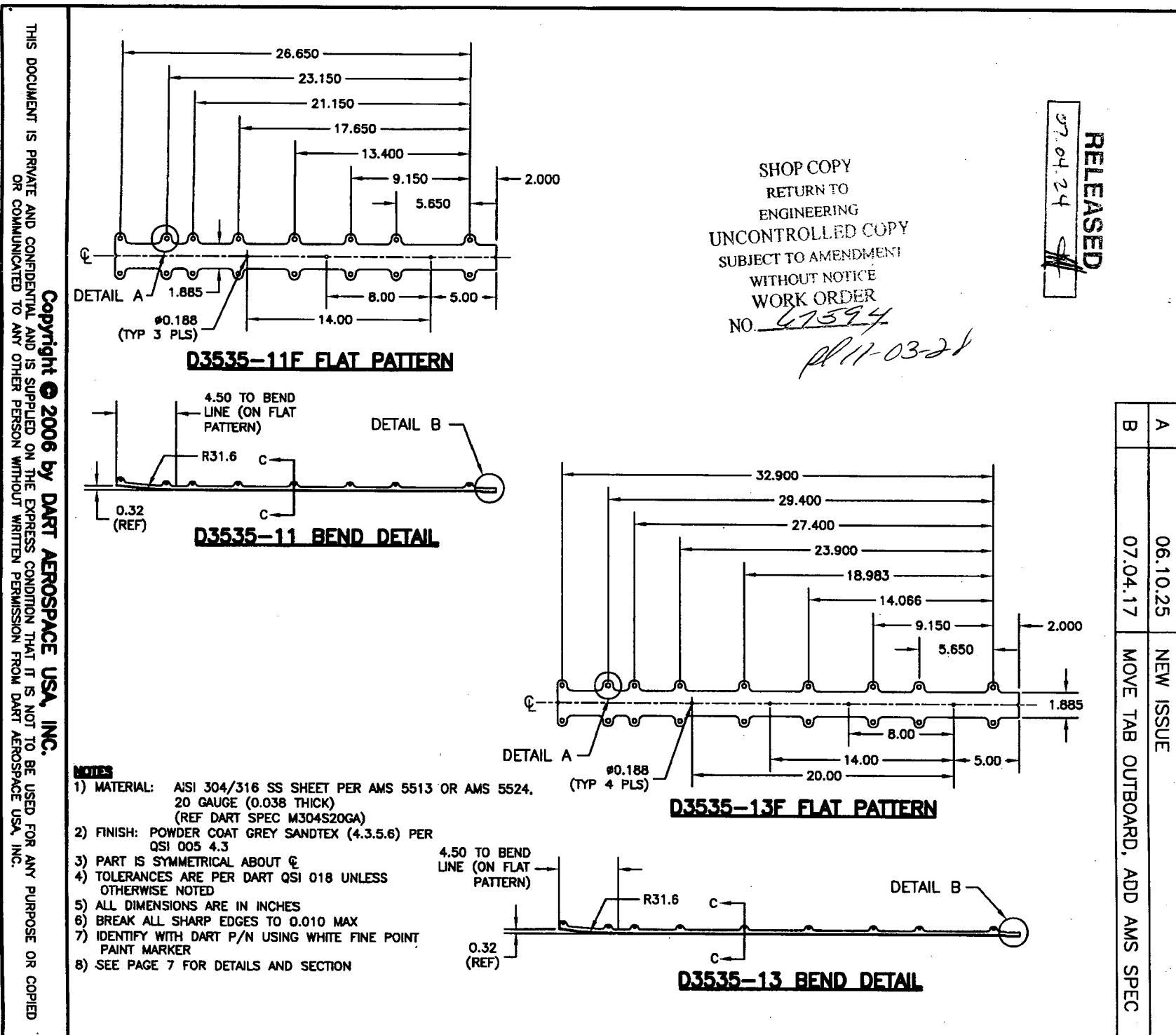
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.886	✓		V HB02	
2.000	+/-0.010	2.002	✗		V	
4.750	+/-0.010	4.750	✓		T HB02	
9.500	+/-0.010	9.500	✓		T	
14.250	+/-0.010	14.250	✓		T	
17.750	+/-0.010	17.750	✗		T	
23.140	+/-0.010	23.140	✗		T	
28.530	+/-0.010	28.530	✗		T	
33.920	+/-0.010	33.920	✗		T	
39.310	+/-0.010	39.310	✗		T	
44.700	+/-0.010	44.700	✗		T	
48.200	+/-0.010	48.200	✗		T	
52.850	+/-0.010	52.850	✓		T	
Ø0.188	+0.005/-0.001	.189	✗		V	
48.00	+/-0.030	48.00	✓		T	
39.00	+/-0.030	39.00	✓		T	
32.00	+/-0.030	32.00	✓		T	
24.00	+/-0.030	24.00	✗		T	
16.00	+/-0.030	16.00	✗		T	
8.00	+/-0.030	8.00	✗		T	
6.00	+/-0.030	6.00	✗		T	
0.300	+/-0.010	.301	✗		V	
0.300	+/-0.010	.305	✗		V	
0.038	+/-0.010	.038	✗		V	

Measured by:	B
Date:	11-4-5

Audited by:	S
Date:	11/04/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	DS



DESIGN CB	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3535
DATE 07.04.17	DATE 06.10.25	TITLE WEARSHOE
		NEW ISSUE
	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

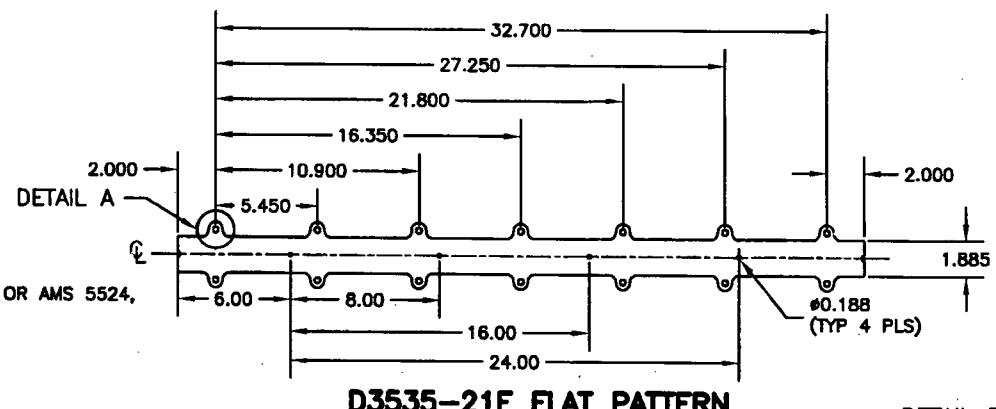
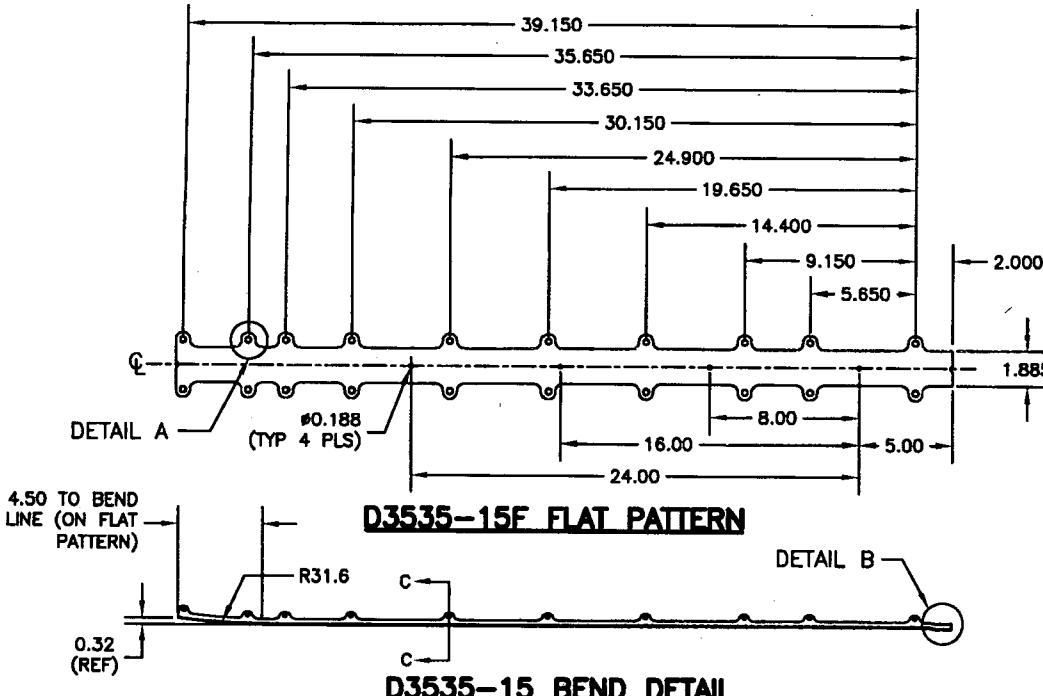
REV. B
SHEET 1 OF 7
SCALE
1:10

DART

RELEASED

07.04.17

W/067597



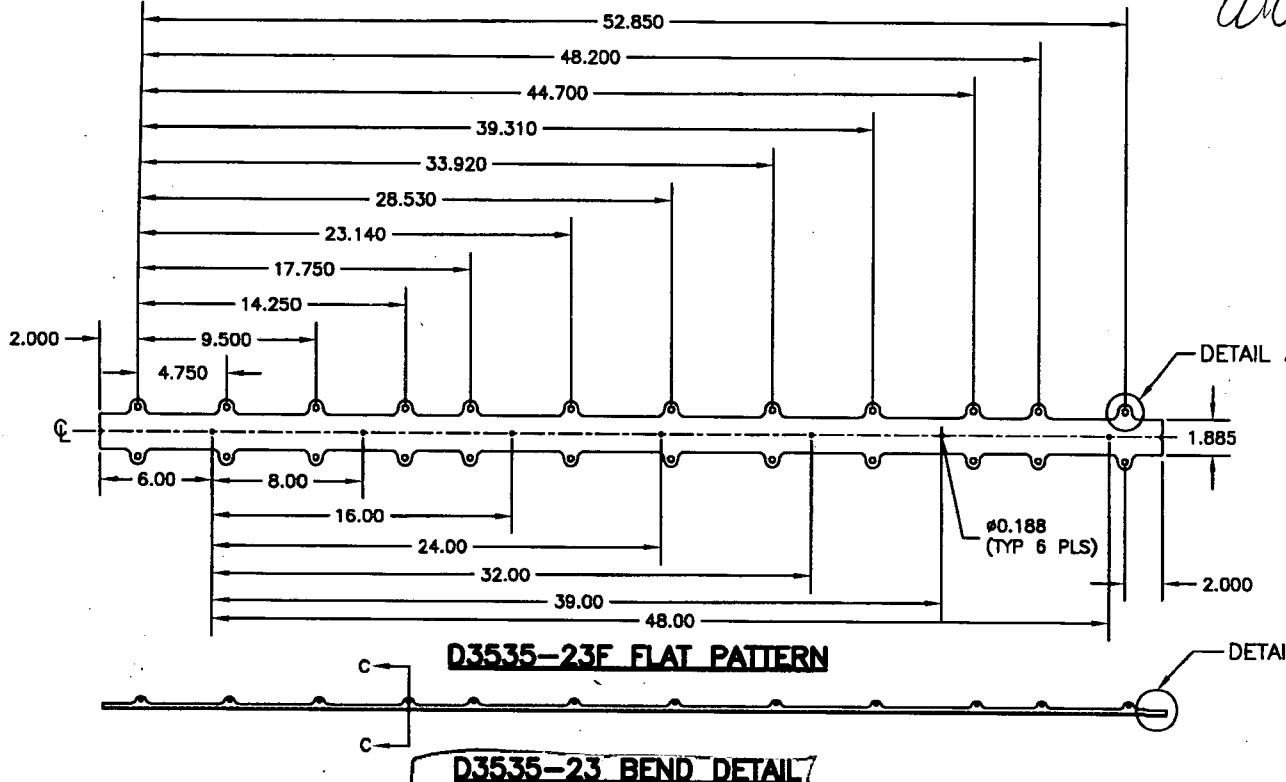
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
07.04.17	PH	D3535
		WEARSHOE
DATE		SCALE
		1:10
		REV. B
		SHEET 2 OF 7

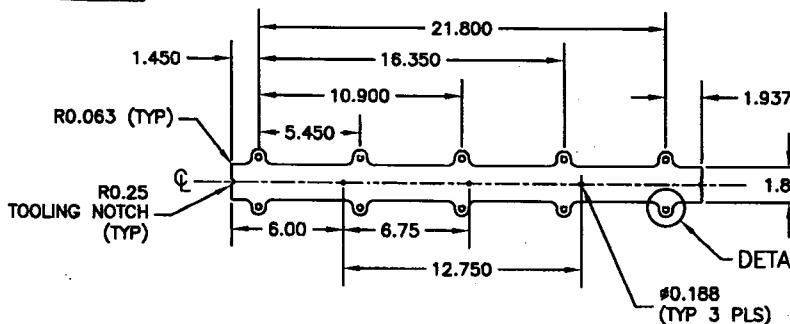
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CHECKED PH	APPROVED PH	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE
		SCALE 1:10

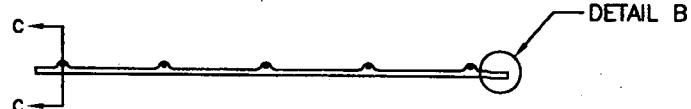


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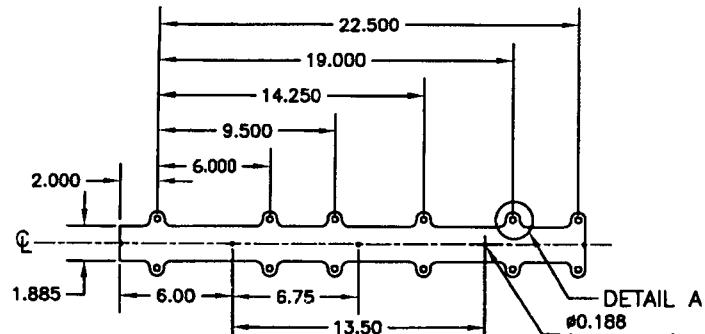
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL



D3535-31F FLAT PATTERN



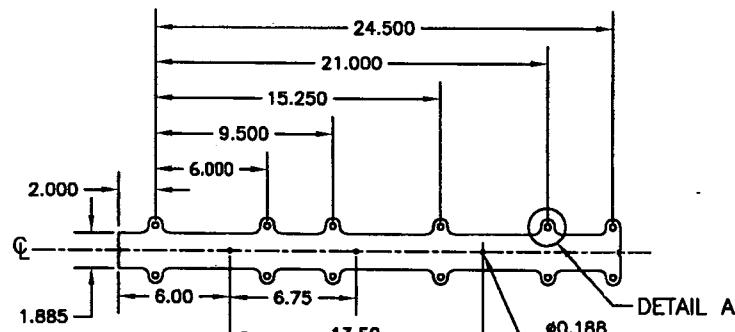
D3535-31 BEND DETAIL

NOTES

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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \textcircumflex
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

WB G7594

RELEASED
07.04.24



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

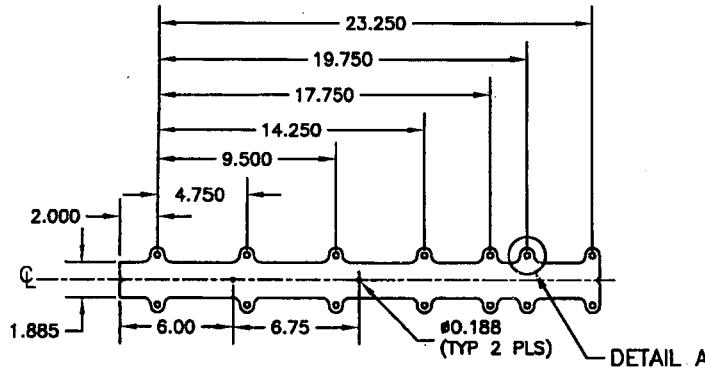
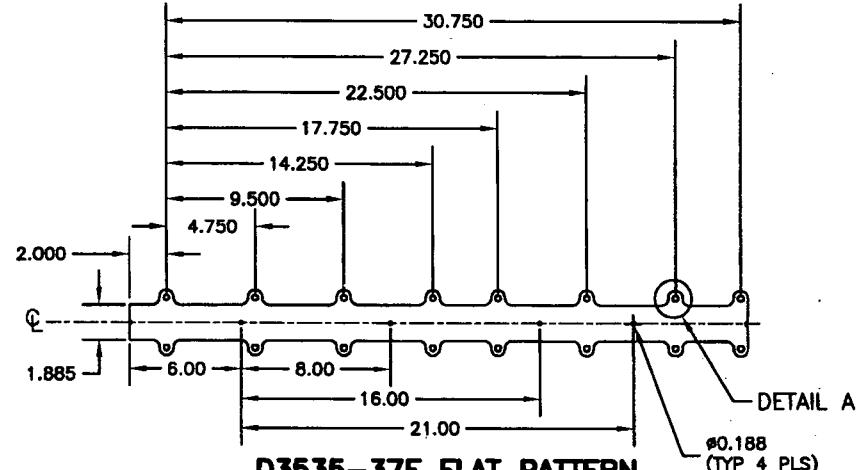
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C.B	PH	
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE		TITLE
07.04.17		WEARSHOE
		SCALE
		1:10
		REV. B
		SHEET 4 OF 7

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
		REV. B
		SHEET 5 OF 7
		SCALE 1:10

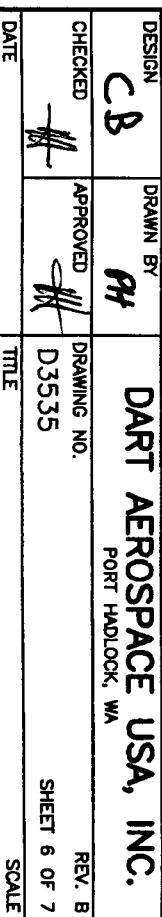
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07.04.17

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

NOTES

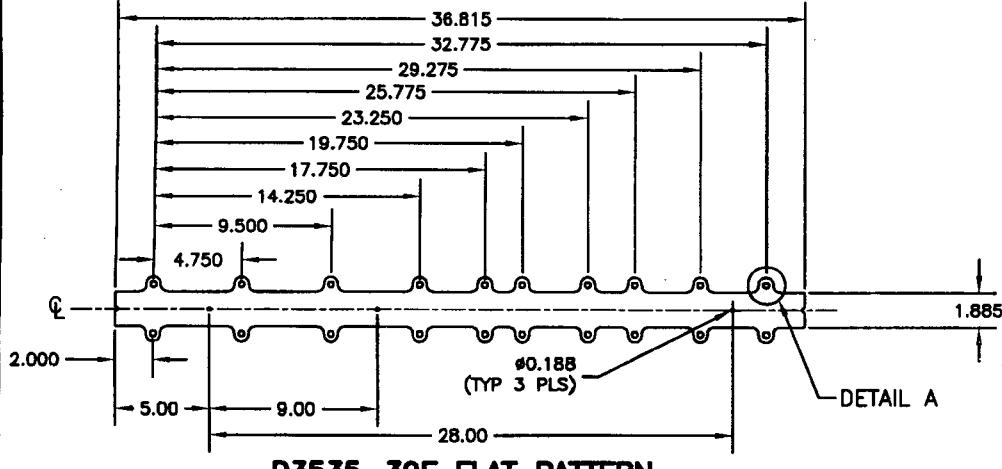
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \mathcal{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



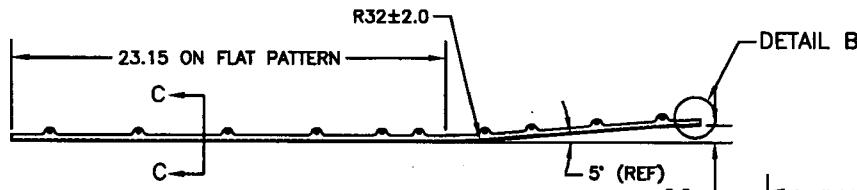
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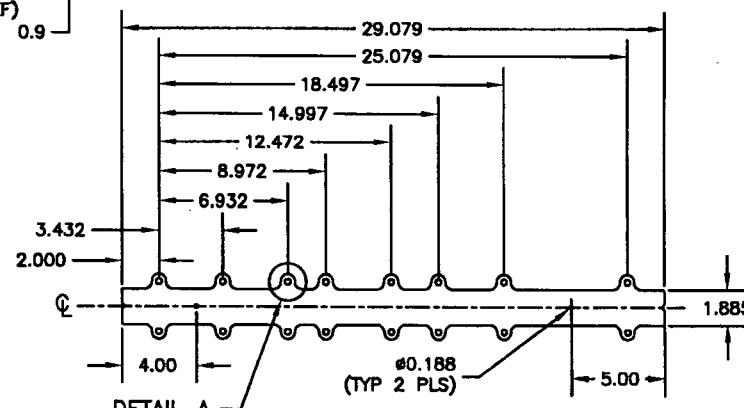
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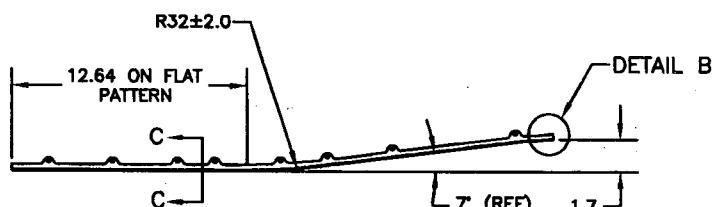
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 RFND DETAIL

NOTES

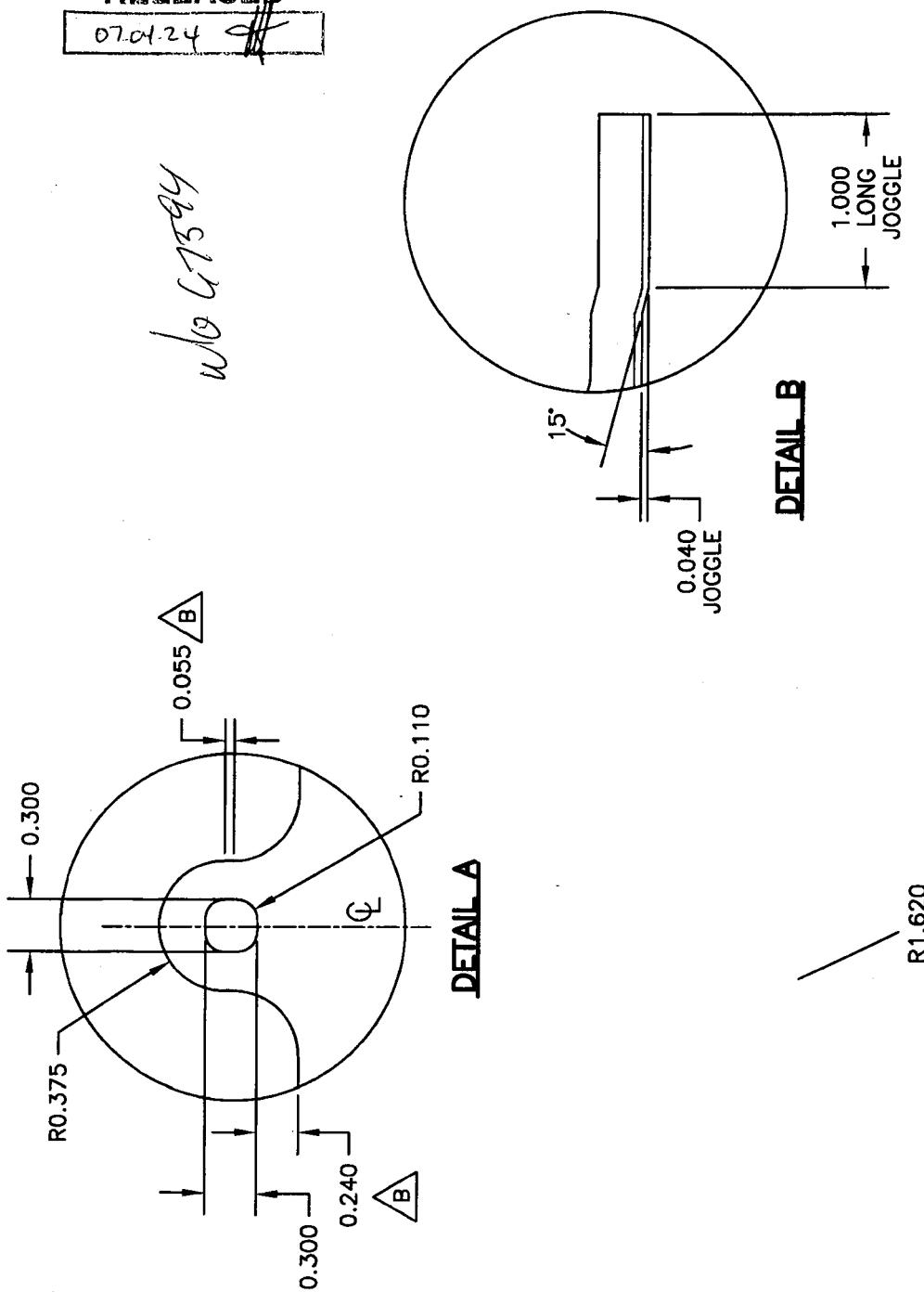
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
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(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DART

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:1	

RELEASED

07.04.24 *[Signature]*

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